

Work Order ID 105496

105496

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Item ID: D2550-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Assembly
 Start Date: 8/07/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/16/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2550	Rev F								

100 Weld per dwg A/R Aluminum rod Batch: 123928 0.00
 Large Fab 125107
 Memo 0.00
 1- Cut D2622 extrusion as per Dwg D2550
 2- Weld lugs as per Dwg D2550 using positioning jig IOT 8432
 3- Weld one end cap
 4- Grind welds around end plate

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
 110
 QC Memo 0.00
 Quality Control

120 QC5- Inspect part completeness to step on W/O 0.00
 120
 QC Memo 0.00
 Quality Control

1 0 M
 13-08-12

0 B-08-B DAS
09

0 13-08-13 DAS
09

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Item ID: D2550-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Assembly

Start Date: 8/07/13

Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/16/13

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

1 0 13.08.14

132

QC7-Inspect Chemical Conversion Coat

0.00

132

QC

Memo

0.00

Quality Control

1x 0 13.08.14

134

Weld per dwg A/R. Aluminum rod Batch: 12507

0.00

134

Large Fab

Memo

0.00

Large Fab

1- Weld cap as per dwg and grind flush
2- Touch up alodine

1 0 13.08.14

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Item ID: D2550-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Assembly
 Start Date: 8/07/13 Start Qty: 1.00 *1*
 Required Date: 8/16/13 Req'd Qty: 1.00 *1*
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
136 *136* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00 13 & 14				1			
138 *138* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 13 & 14				1			
140 *140* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: 9:05 FINISH TIME: 9:30 320 °F	0.00 0.00 white h							

1X/ M-1 13/08/15

m126125

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Item ID: D2550-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly
 Start Date: 8/07/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/16/13 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFinish Hand Finishing	Wing Walk as per dwg QS1005 4.4 Batch <u>114 126</u> 2003 Memo	0.00				<u>1x</u>	<u>4</u>	<u>all</u>	<u>13/08/15</u>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<u>27</u> <u>13 8 15</u>					
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							<u>PP105513</u> <u>3/8/16</u> <u>SD</u>

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Item ID: D2550-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Assembly

Start Date: 8/07/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 8/16/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 13-08-16
MLJ 13-08-16

Picklist Print

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Work Order ID: 105496

Parent Item: D2550-2

Parent Item Name: Step Assembly

Start Date: 8/07/13

Required Date: 8/16/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP D 00.06.26Removed P/O for powder coat, added level 9 inspectionEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No			100	Each	174.3700	1	1		8/13/08.12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA003		174.37							
				101765		118							
				81507		4							
				89750		8.27							
				98024		2.1							
				99789		42							
D2875 End Plate		Manufactured	No			100	Each	10.0000	1	1		8/13/08.12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA003		10							
				45665		10							
D2875 End Plate		Manufactured	No			134	Each	10.0000	1	1		8/13/08.14	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA003		10							
				45665		10							
D2936-1 Lug		Manufactured	No			100	Each	2.0000	3	3		8/13/08.12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Mezz	3105502	2							
				11868		2							
D2936-3 Lug		Manufactured	No			100	Each	2.0000	3	3		8/13/08.12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Mezz	3105503	2							
				2197		2							



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2550	REV. F SHEET 1 OF 2
DATE 99.11.03		TITLE STEP ASSEMBLY	SCALE NTS
A	96.03.28	NEW ISSUE	
B	97.04.03	CHANGE EXTRUSION AND LEGS	
C	97.07.18	ADD WING WALK SPEC	
D	97.09.10	CHANGED LEGS	
E	99.10.20	D2875 WAS D2669-45	
F	99.11.03	ADDED D2936, REMOVED D2695/96/97	

RELEASED
KE 99.11.19

Qty -1	Qty -2	Part Number	Description
X		D2550-1	HELI-ACCESS-STEP™ LH, HEAVY DUTY
	X	D2550-2	HELI-ACCESS-STEP™ RH, HEAVY DUTY
*	*	* D2622	* EXTRUSION
2	2	D2875	END PLATE
3	3	D2936-1	LUG
3	3	D2936-3	LUG

* NOTE: CUT EXTRUSION D2622 PER SHEET 2

*no
D2550*

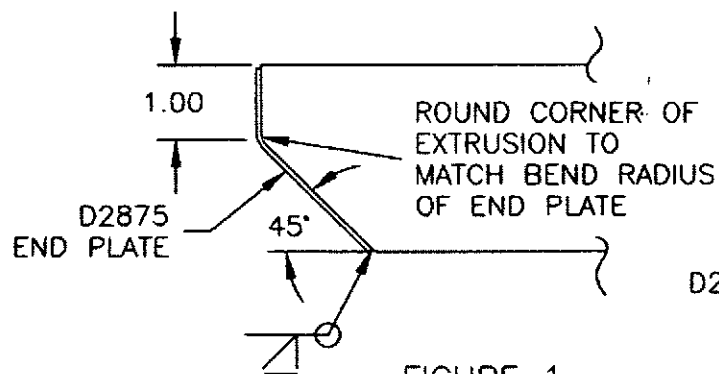
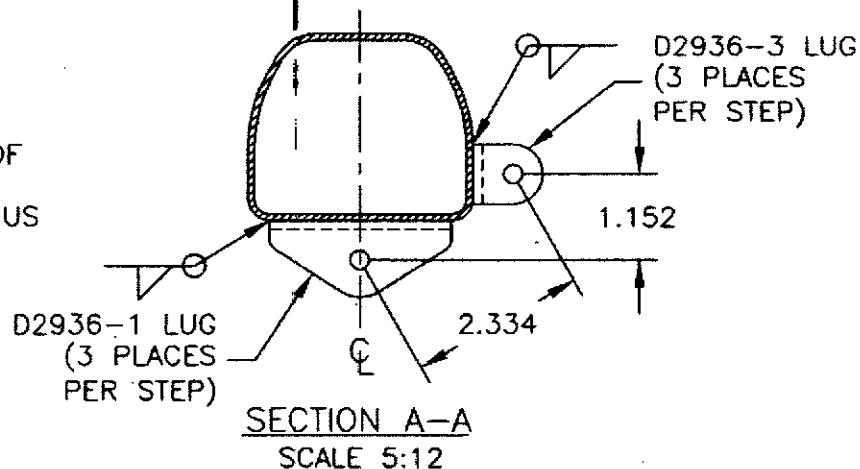
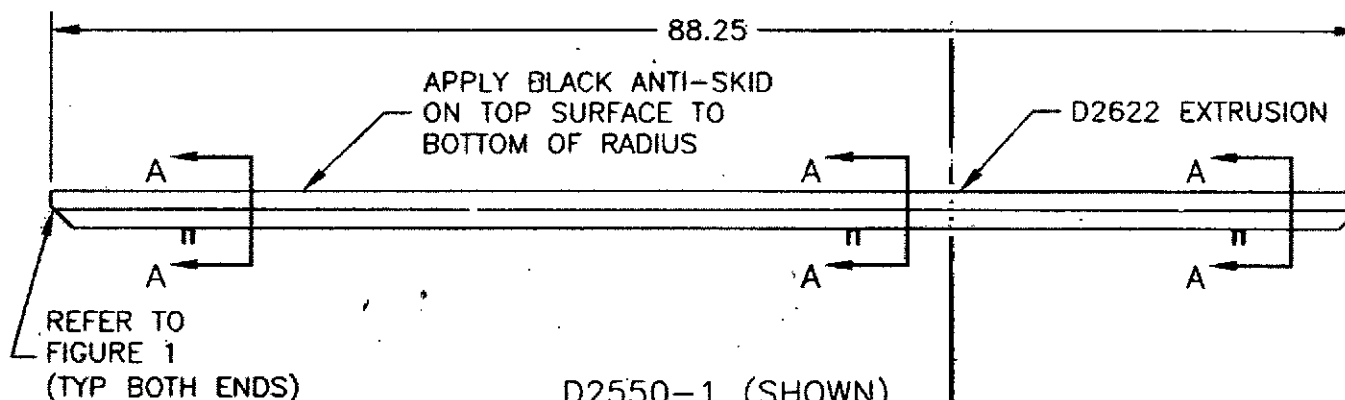
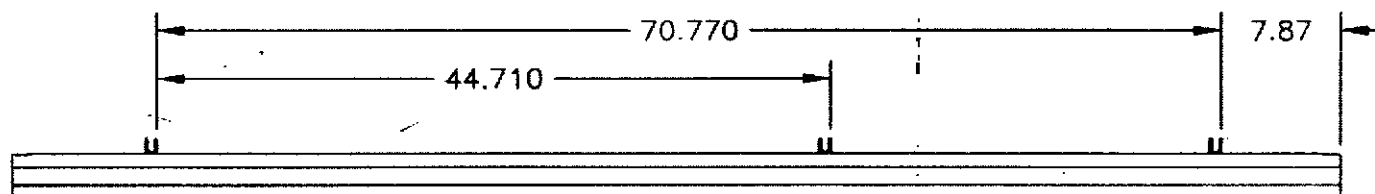


FIGURE 1
SCALE 5:12



SECTION A-A
SCALE 5:12



D2550-1 (SHOWN)
D2550-2 (OPPOSITE)

WELD PER DART QSI 004

FINISH: ACID ETCH AND ALODINE ASSEMBLY PER DART QSI 005 4.1

POWDER COAT PER DART QSI 005 4.3 WHITE (4.3.5.1) OR

GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7)

BLACK ANTI-SKID PAINT PER DART QSI 005 4.4 AFTER POWDER COAT

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART



DESIGN	AE	DRAWN BY	AE	DART AEROSPACE LTD
CHECKED	AE	APPROVED	AE	HAWKESBURY, ONTARIO, CANADA
DATE	99.11.03	TITLE	D2550	REV. F
		STEP ASSEMBLY		SHEET 2 OF 2
				SCALE 1:12

RELEASED
AE 99.11.14

